

NUR - 1A-7676



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5491-1

Job Sheet 196930



Part No: D5491-1

Job Qty: 14 pcs

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/19

Job Tracking No:

Due Date: 6/28/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: D5491 REV.B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/02 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Conventional Mill - 1	14 pcs		6/28/19	0.00	7.00	Conventional Mill - 1 - B4B			DAS 63 9-89
							Conventional Mill - 2 - B4B			
115	QC 2	14 pcs		6/28/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			
							QC 2 - 65			
							QC 2 - 5			
							QC 2 - 71			
							QC 2 - 73			
							QC 2 - 69			
117	HAAS 4 Axis - B4B	14 pcs		6/28/19	1.00	7.00	HAAS - 1 - B4B			
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			

RT
SPACE

No: S195435



1-1
6930
Batch: S195435

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Various STC's

Date: 07/03/19

14/73

DAS
63
9-89

Plex 6/25/19 3:11 PM Dart.Renwick.Jenni



Container No: S195435



Part: D5491-1

Job No: 196930

Serial No/Batch: S195435

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 07/03/19

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P.T.O.

B.A 19-07-05/mm. 2019/07/0

124 QC 2	14 pcs	6/28/19	0.00 0.00	HAAS - 4 - B4B	
				QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
128 QC 8	14 pcs	6/28/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Handfinish - 1-1 Chemical-B4B	14 pcs	6/28/19	0.00 1.75	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	

B.A 19-07-05
mm 2019/07/06

mm 19/07/19

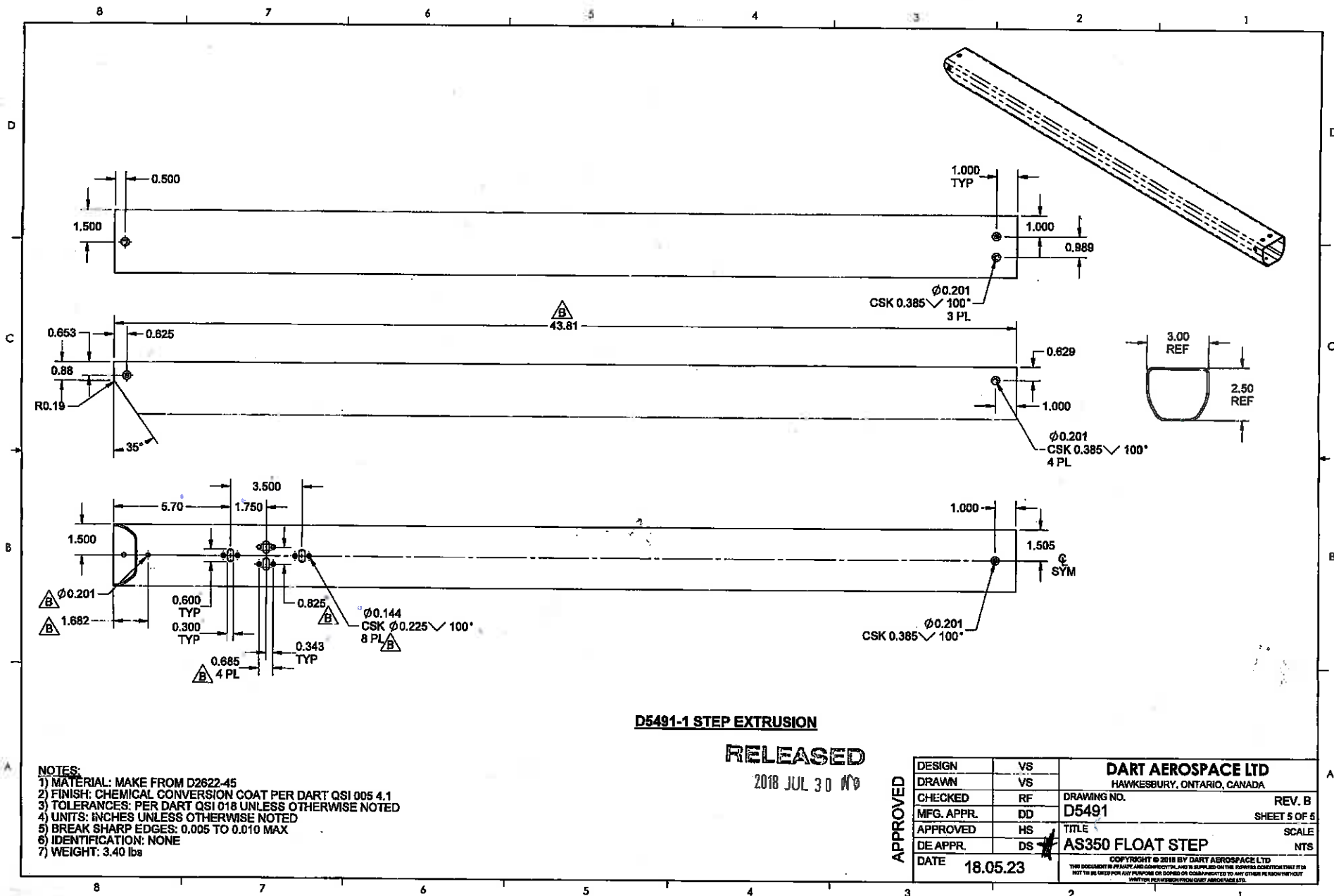
JUL 10 2019

				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	14 pcs	6/28/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
160 Packaging 3-1 - Stock - B4B	14 pcs	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

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				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	14 pcs	6/28/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	53
Part Op 110 - (Fabricate per Dwg), 1- CUT EXTRUSION AS PER DWG (Make sure ends are cut square) 2- DRILL HOLES Descriptions: USING DT10168 ON ONLY ONE END AS PER DWG AND DEBURR. (Drill one hole at the time and put a drill bite in every holes before drilling the next) 117 - 1-Machine slot (4 places) and drill holes with c/sinks as per ***USE DT10435*** 2- DRILL ALL FWD HOLES AS PER DWG 3-C/SINK ALL HOLES AS PER DWG 4- DEBURR 124 - (QC2- Inspect parts off machine FAI/FAIB) 128 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat) 160 - (Identify as per dwg & Stock Location: _____), ***GA*** 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item D2622-120C	Component Name Step Extrusion	Quantity 7 pcs (.5 ea)	Operation 110-Conventional Mill - 1	Container S137767	
Job Allocations					
Operation 110-Conventional Mill - 1	Component Part D2622-120C	Required 7	Inventory 72	Allocated 0	
Part Specifications					
Specifications could not be found.					

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S137767

DART AEROSPACE LTD		Work Order: 196930
Description: Step Extrusion		Part Number: D5491-1
Inspection Dwg: <i>Sum on P.W.</i> Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	± 0.010	1.500	✓		Vernier JVDs	
0.500	"	0.500	✓		"	
1.000 Typ.	"	1.000	✓		"	
1.000	"	1.000	✓		"	
0.989	"	0.989	✓		"	
0.653	"	0.653	✓		"	
0.88	± 0.030	0.890	✓		"	
0.625	± 0.010	0.625	✓		"	
0.629	"	0.630	✓		"	
1.000	"	1.000	✓		"	
35°	$\pm 1/2^\circ$	35.5°	✓		CNC-03	
R0.19	± 0.030	R0.19	✓		Vernier JVDs	
1.500	± 0.010	1.500	✓		"	
1.682	"	1.686	✓		"	
1.000	"	1.000	✓		"	
1.505	"	1.505	✓		"	
0.201 x 9	+0.005 -0.001	0.205	✓		"	
0.385 x 8	+0.006 - "	0.390	✓		"	
100° x 8	$\pm 1/2^\circ$	100°	✓		"	
3.00 Ref	± 0.030	3.004	✓		"	
2.50 "	$\pm$ "	2.508	✓		"	
43.81	$\pm$ "	43.810	✓		Tape	
5.70	+/-0.30	5.697	✓		H-G	31006
1.750	+/-0.10	1.750	✓		"	"
3.500	+/-0.10	3.500	✓		"	"
0.600	+/-0.10	0.600	✓		Vern	GA-13
0.300	+/-0.10	0.300	✓		"	"
0.685	+/-0.10	0.685	✓		"	"
0.343	+/-0.10	0.343	✓		"	"
0.825	+/-0.10	0.825	✓		"	"
φ 0.144	+0.005/-0.001	φ 0.144	✓		"	"
φ 0.225 x 100°	+/-0.10 x +/-2°	φ 0.227 x 100°	✓		"	"

Measured by: <i>B.A.</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 19/7/13	Date: 14/07/09	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Entered: TK Date: Oct 31/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7676

Route update only ☐

Job: <u>D5491-1</u> Part No. <u>196930</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☒ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
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Date: JUL 17 2019 Sequence #: 150 QTY Affected: 50ft x 9 MRB (QSI042) **DAS 55 9-89 JUL 17, 2019**

Description Work Order Deviation	Disposition	Completed By DAS 40 9-89 JUL 17 2019
- steps got crushed during install on jig with rubber mallet	- scrap no replace	Lead hand / Supervisor <u>only 19/07/17</u>
		QC / QA Coordinator DAS 40 9-89 JUL 17 2019

Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☒ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details:	